

# Work Order ID 85273

**\*85273\***

Page 1

June-05-12 10:53:30 AM

Item ID: D3772-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Back Leg

Start Date: 05/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/05 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3772

Rev A

100

BAND SAW

0.00

**\*100\***

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 31.500" long

110

HAAS CNC VERTICAL MACHINING #1

0.00

**\*110\***

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Foliō FA787 Rev: AA & Dwg D3772 Rev: A

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

Memo

0.00

Quality Control

ent 12/06/09

6 x

ET

12-06-10

Y6

ET

12-06-10

Y6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Start Date: 05/06/2012 Start Qty: 6.00

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Required Date: 19/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
140		0.00							
<b>*140*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-cut tube to length as per dwg D37722- deburr3-bend tube as per dwg D3772								
150	QC5- Inspect part completeness to step on W/O	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									

*am 12/06/11*

*6 10*

*6 9*

*FF 12-07-13*

*DAS 16 2-03 12/07/13*

*(46)*

W/O:		WORK ORDER CHANGES					
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Page 3

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Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Back Leg

Start Date: 05/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 19/06/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: **81254**, 0.00**\*160\***

Packaging

Memo

0.00

Packaging

**6x****SP**  
**12-7-13**

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

**12/17/17**  
**ME**  
**12-07-16**

W/O:		WORK ORDER CHANGES					
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# Picklist Print

June-05-12 10:53:33 AM

Page 1

Work Order ID: 85273

\*85273\*

Parent Item: D3772-1

\*D3772-1\*

Parent Item Name: Back Leg

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC  
IPP Rev:B 08-09-24 Now on Haas JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR1.250W.125		Purchased	No			110	f	54.2500	2.6252	16.58021			

\*M304TR1 250W 125\*

\*\*

304 RD Tube 1.250 x .125w

Location

Loc Qty

Loc Code

MAT037

54.25

113494

6

114812

4

→ 121317

44.25

16.59 on 12/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

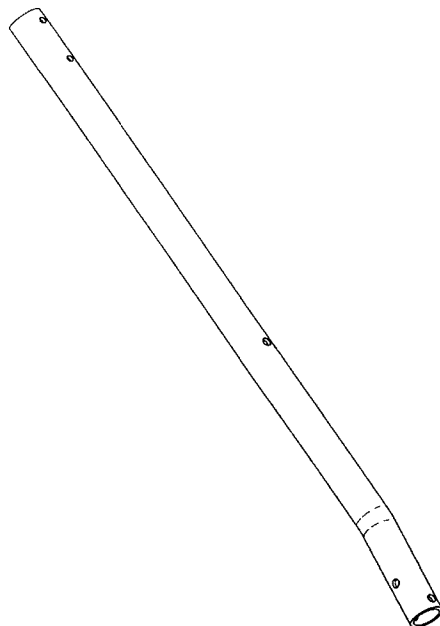
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**D3772-1 BACK LEG**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER

NO. 85273 MLO  
12/06/05

**RELEASED**  
08-06-03

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS TUBING 1.25" OD X 0.125" WALL (REF DART SPEC M304TR1.25W.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.26 lbs

A	NEW ISSUE	HS	08.06.03
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D3772</b>	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BACK LEG</b>	NTS
DATE	08.06.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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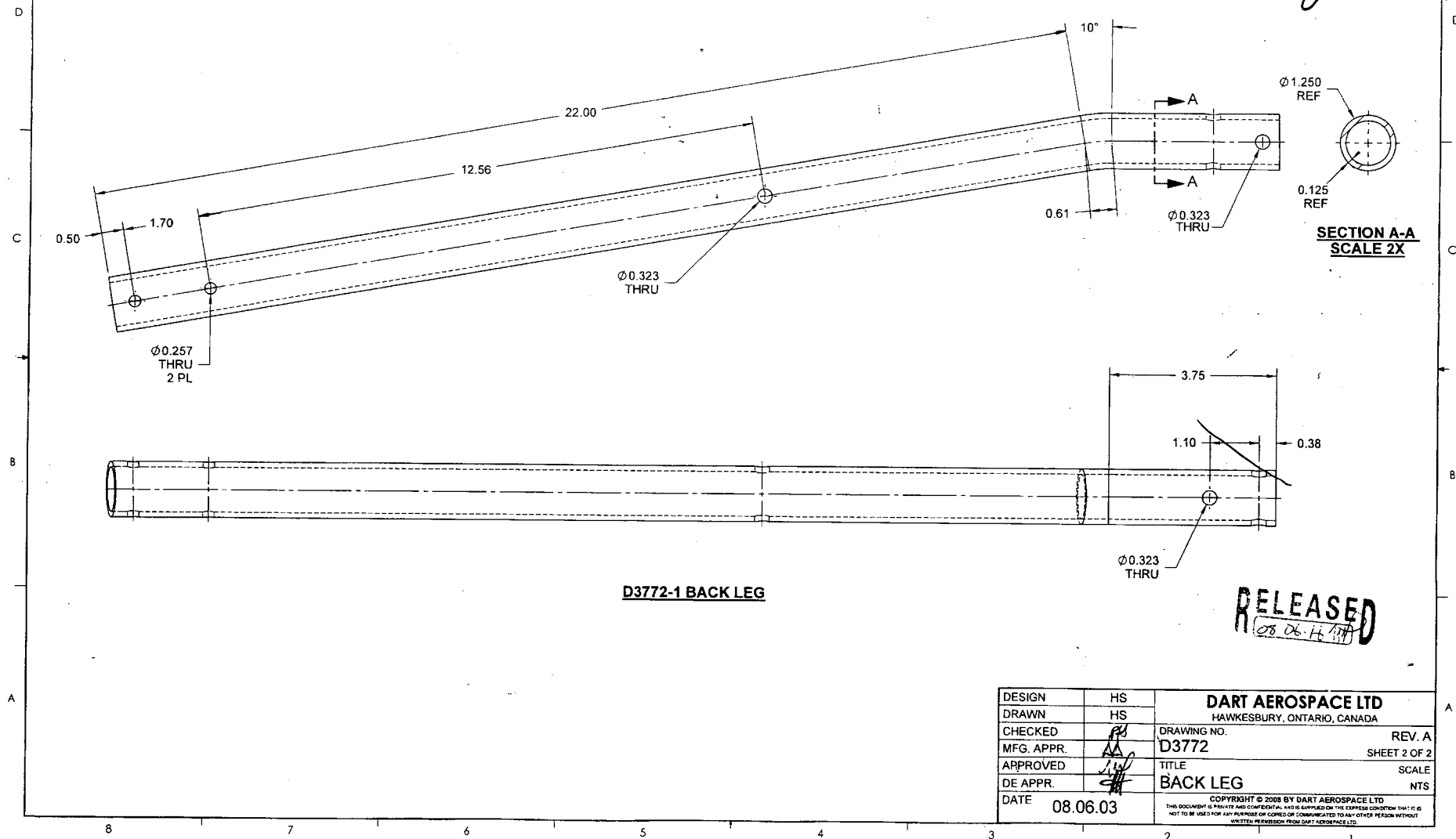
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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05273



SECTION A-A  
SCALE 2X

RELEASED  
08.06.03

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CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	AA	D3772	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	BACK LEG	NTS
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# Dart Aerospace Ltd

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